

Date: Thursday, 3/8/2007 12:38:41 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH PLATE
Job Number	: 31111		
Estimate Number	: 10511		
P.O. Number	: N/A	Part Number	: D2621
This Issue	: 3/8/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2621 REV. B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29995	Drawing Revision	: B
Written By		Material	: N/A
Checked & Approved By		Due Date	: 4/2/2007
Comment	: Est: 02.02.28	Qty:	30
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S040	5052-H32 .040 Sheet	
	Comment: Qty.: 0.0656 sf(s)/Unit Total : 1.9688 sf(s)		
	Material: 5052-H32 (QQ-A-250/8) 0.040" thick		
	(M5052H32S040)	Batch: H102448	SAD 07/03/11
2.0	WATER JET	FLOW WATER JET	
	Comment: FLOW WATER JET		
	1-Cut as per Dwg D2621		
	Dwg Rev: B		
	Prog Rev: B		
	2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		SAD 07/03/11
4.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK		MF 07-03-13
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
	Comment: HAND FINISHING RESOURCE #1		MA 07/03/12
	Chemical Conversion Coat as per QSI 005 4.1		30
			30A
			07/03/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07K3/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 12:38:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH PLATE

Job Number: 31111

Part Number: D2621

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



m100700



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FL/m-h 07/03/14 (1)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



QPay/03/15 (30) W

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

QPay/03/15 (30) W

9.0 QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

QPay/03/19

Job Completion



U 07.03.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31111
Description: Latch Plate	Part Number:	D2621
Inspection Dwg: D2621	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

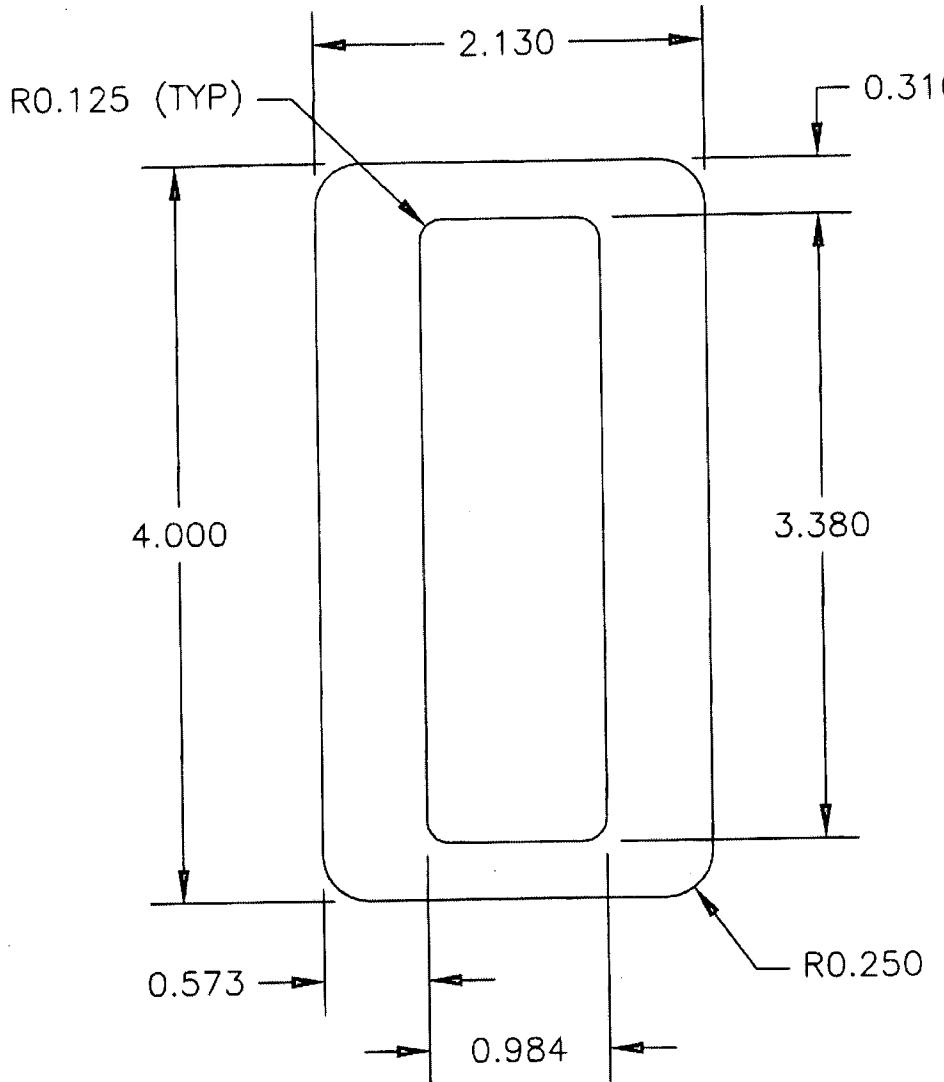
Measured by:	SAD	Audited by:	BS	Prototype Approval:	N/A
Date:	07/03/11	Date:	07/03/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	JL



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2621	REV. B SHEET 1 OF 1
DATE 00.06.01		TITLE LATCH PLATE	SCALE 1:1
A	96.08.15	NEW ISSUE	
B	00.06.01	ADDED FINISH; R0.125 WAS R0.118	

RELEASED
(00.06.05 - D)



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) OR 2024-T3
 (QQ-A-250/4) 0.040 THICK
 FINISH: CHEMICAL CONVERSION COAT PER DART 005 4.1
 POWDER COAT BLACK SANTEX (REF. 4.3.5.7) PER DART QSI 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
 RETURN TO
 ENGINEERING
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 SUBJECT TO AMENDMENT
 4.3 WITHOUT NOTICE
 WORK ORDER
 NO. *31111*